: SPACEDOOR INSTALLATION

Date:

Thursday, 6/1/2006 8:28:14 AM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Type

Job Number : 10568 **Estimate Number**

: 27323

P.O. Number

AU:

This Issue

: 6/1/2006

: NC Prsht Rev.

: NIA First Issue : 26394 **Previous Run**

Written By

Checked & Approved By

Comment

: Est Rev:A 05.04.27

S.O. No. : NA

: SMALL /MED FAB

Drawing Name

Part Number

: D412694011 : N/A

Drawing Number Project Number

Drawing Revision Material

Due Date : 6/8/2006

: N/A

: N/A

NIG:

Qty:

1 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-694-011

2.0

1.0



Could see 24660

wald see w/o

Comment: Sub-Component DOOR ASSEMBLY IN PROGRESS

DOOR ASSEMBLY

DOOR ASSEMBLY

Comment: Sub-Component DOOR ASSEMBLY IN PROGRESS

4.0

3.0

27323C

Could see

Comment: Sub-Component DOOR ASSEMBLY IN PROGRESS

5.0

27323D



Comment: Sub-Component DOOR ASSEMBLY IN PROGRESS

6.0 27323E



DOUBLER KIT



Comment: Sub-Component DOUBLER KIT

7.0

27323F

DOUBLER KIT



Comment: Sub-Component DOUBLER KIT

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector				

NCR:			NORK ORD	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Design Mgr	QC Inspector
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	e & initial all entries				QA: N/C	Closed:	Date:

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Date:

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEDOOR INSTALLATION

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Job Number:



Seq. #:

Machine Or Operation:

Description:

8.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 2008/60 D3119-041 Cover Assembly

D3119-042

Cover Assembly

D3140-05/-07 Door

(for D412-694-01/-03)

D3140-06/-08 Door

(for D412-694-02/-04)

Supplier: Delastek

Ship to Delastek

Qty Part Number

Description

D3140-5-7 D3140-6-8 Doubler Kit

Doubler Kit

Batch

27323 E

9.0 PACKAGING 1

PACKAGING RESOURCE #1





Receive & Inspect For Transit Damage

Ensure material certification is attached

QC6

DIMENSIONAL CHECK



Al 06/05/31 (1)

Comment: DIMENSIONAL CHECK

DIMENSIONAL C Visual inspection.

Check for void spot and pins.

Check over all dimensions and windows as per Dwg D3140.

Bring to composite room for assembly

11.0

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

12.0

D412694015

Replacement Window Kit



Comment: Qty.:

4.0000 Each(s)/Unit

Total:

4.0000 Each(s)

Pick: Packing Kit

Batch

Ba5267



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Form: rprocess

W/O:			WC	RK ORDER CHANGES	3				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
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NCR:	Τ		WORK ORDE			'		T	T
DATE	STEP	STEP Description of NC Section A	Initial Design Mgr	Corrective Action Section B Action Description Design Mgr	Sign 8	Verific Section		Approval Design Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Category	: NCR:	Yes No	DQA:		Date:	
NOTE: D	ate & initia	al all entries		,	DA: N/C CL	osad:			

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Date: Thursday, 6/1/2006 8:28:14 AM User: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: SPACEDOOR INSTALLATION** Job Number: 27323 Part Number: D412694011 Job Number: Seq. #: Description: **Machine Or Operation:** 13.0 D41269401 Door Assembly Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Packing Kit Batch D41269402 14.0 Door Assembly Comment: Qty... Total: 1.0000 Each(s) 1.0000 Each(s)/Unit Pick: Packing Kit Z7323B Batch 15.0 D41269403 Door Assembly Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Packing Kit 7223C Batch D41269404 16.0 Door Assembly Comment: Qty.: Total: 1.0000 Each(s) 1.0000 Each(s)/Unit Pick: Packing Kit 323D 17.0 D2126 Seal Comment: Qty.: 12.1666 f(s)/Unit Total: 12.1666 f(s) Seal 625702 v Batch D30901 18.0 Shim 0.250 Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Shim 0.250 Batch 19.0 D30903 Shim 0.125 Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Shim 0.125

M16579 V

Batch

W/O:			WO	RK ORDER CHANGE	S				
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DATE	STEP	Description of NC		Corrective Action Section I		Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign 8 Date	Sect	ion C	Design Mgr	QC Inspector
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4		·							
Part No	:	PAR #:	Fault Category	: NCR:	Yes No	DQA:		Date:	
NOTE: D	ate & initia	al all entries			QA: N/C CI	nead:			

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Date: Thursday, 6/1/2006 8:28:14 AM User: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: SPACEDOOR INSTALLATION** Job Number: 27323 Part Number: D412694011 Job Number: Seq. #: **Machine Or Operation:** Description: 20.0 D31081 Decal Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Decal B17029 Batch D31082 21.0 Decal Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Decal B17030 Batch 22.0 D31083 Decal Comment: Qty.: Total: 4.0000 Each(s)/Unit 4.0000 Each(s) Decal B18627 Batch D31085 23.0 Decal Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Decal Batch 24.0 D31087 Decal Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Decal B18163 **Batch** 25.0 D31161 Seal P/N 110-004-2 Comment: Qty.: 8.3333 f(s)/Unit Total: 8.3333 f(s) Seal P/N 110-004-2 Batch 26.0 D31163 Seal 110-160-1 Comment: Qty.: 8.3333 f(s)/Unit Total: 8.3333 f(s) Seal 110-16Q-Batch Page 4

Form: rprocess

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W/O:			WC	ORK ORDER CHANGES	<u></u>				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
NCR:			WORK ORDI	ER NON-CONFORMANO	E (NCF	₹)			
DATE	OTED	Description of NC		Corrective Action Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign 8 Date	Section		Design Mgr	QC Inspector
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
NOTE: Date & initial all entries			QA: N/C Closed:	Date:
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Date: Thursday, 6/1/2006 8:28:14 AM User: Kim Johnston **Process Sheet Drawing Name: SPACEDOOR INSTALLATION** Customer: CU-DAR001 Dart Helicopters Services Job Number: 27323 Part Number: D412694011 Job Number: Seq. #: **Machine Or Operation:** Description: 27.0 D31169 Seal ZX1267 Comment: Qty.: 8.6666 f(s) Total: 8.6666 f(s)/Unit Seal ZX1267 Batch D31183 28.0 Sign Assembly Comment: Qty.: 4.0000 Each(s) 4.0000 Each(s)/Unit Total: Sign Assembly Batch 29.0 D31185 Sign Assembly 4.0000 Each(s) Comment: Qty.: 4.0000 Each(s)/Unit Total: Sign Assembly Batch 30.0 D31281 Shim Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Shim Batch D314415 31.0 Doubler Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Doubler Batch 32.0 D33001 Window Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Window Batch 33.0 BSP45 Commercial Rivet Comment: Qty.: 48.0000 Each(s)/Unit Total: 48.0000 Each(s) Commercial Rivet W/182 Batch

W/O:		WORK ORDER CH	IANGES				
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NCD.		WORK ORDER NON-CONF	ORMANCE (NC	र)			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B				Approval			
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Verification Section C	Approval Design Mgr	QC Inspector			
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Part No:	PAR #:	Fault Category: N	CR:	Yes No DQA:	Date: 06/07/10
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

Date: Thursday, 6/1/2006 8:28:15 AM User: Kim Johnston **Process Sheet Drawing Name: SPACEDOOR INSTALLATION** Customer: CU-DAR001 Dart Helicopters Services Job Number: 27323 Part Number: D412694011 Job Number: Seq. #: **Description: Machine Or Operation:** INSPECT 100% KITS FOR COMPLETENESS 34.0 QC4 Comment: INSPECT 100% KITS FOR COMPLETENESS PACKAGING 1 35.0 PACKAGING RESOURCE # Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-694-011 Location: PPP Rev: 36.0 DC **Comment: DOCUMENT CONTROL** Inspection Level 21 Job Completion (Lo 7/06/04

W/O:			W	ORK ORDER CHANG	ES				
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		Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
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Part No	1.	PAR #:	Fault Categor	v· NCR·	Yes No	DOA:		Date:	
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